

pru

Work Order ID 83277

\*83277\*

U/R

Page 1

April-16-12 2:27:34 PM

Item ID: D350-748-141TRN

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID: U/R

Item Name: Crosstube Turning Detail

Stop \*NS2\*

Start Date: 16/04/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 30/04/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 12/04/16 Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D350-748-141

F U/R

OK 12.04.16

0.00

KC/BFS 12-4-20

\*100\*

MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs on both ends as per Folio FA648

2-Turn first side as per Folio FA648

3- File transition lines smooth.

FOLIO REV: N/A BFS 12/04/20

DWG REV: PG1

110

QC1- Inspect dimensions to dimension sheet

0.00

\*110\*

QC

Memo

0.00


Quality Control

KC/BFS 12-4-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-4-20	120	DIMENSION 2.272 IS NOW 2.258. DIMENSION IS (.014) UNDER NOMINAL DIMENSION. CAUSED BY VIBRATION.	W 12/11/23	0.014" under tolerance. SCRAP TUBE. & Replace. B72511 P12.04/20	KC 12-4-20	 12-4-23	W 12-01-23	S 12/11/23

NOTE: Date & initial all entries

# Work Order ID 83277

**\*83277\***

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April-16-12 2:27:34 PM

Item ID: D350-748-141TRN  
Revision ID: U/R  
Item Name: Crosstube Turning Detail

Accept

**\*N900040100\***

Setup Start **\*NS1\***  
Stop **\*NS2\***

Start Date: 16/04/2012 Start Qty: 1.00 **\*1\***  
Required Date: 30/04/2012 Req'd Qty: 1.00 **\*1\***  
Reference:

Cust Item ID:  
Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 0.00

**\*120\***

Mori Seiki  
Mori Seiki CNC Lathe Large

MORI SEIKI CNC LATHE LARGE

Memo

0.00

1-Turn second side as per Folio FA648  
2- File transition lines smooth.  
3-Scribe Part & Batch as per Dwg D350-748-141  
FOLIO REV: N/A 018 12/04/20  
DWG REV: PG1

KC/018 12-4-20

130 0.00

**\*130\***

QC  
Quality Control

QC1- Inspect dimensions to dimension sheet

Memo

0.00

KC/018 12-4-20

140 0.00

**\*140\***

QC  
Quality Control

QC8- Inspect parts - second check

Memo

0.00

DP 12-4-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 83277

**\*83277\***

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April-16-12 2:27:34 PM

Item ID: D350-748-141TRN

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID: U/R

Item Name: Crosstube Turning Detail

Stop **\*NS2\***

Start Date: 16/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 30/04/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

**\*150\***

Crosstubes

Large Fab

0.00

Memo

0.00

Crosstubes

Grind machining marks

*Rm*  
12-4-23

160

**\*160\***

Outsource1

Outsource process - Heat Treat

0.00

Memo

0.00

Outsource process - Heat Treat

Issue P/O: \_\_\_\_\_  
Heat Treat to min 180 KSI As per Dwg D350-748-141  
(MIL-T-6736 OR AMS 2759-1C)  
Sand Blast tube after Heat Treat  
Possible Supplier: Vac Aero  
Ensure Certificate of Conformity is attached

170

**\*170\***

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

Packaging

Ensure certificate of conformaty is attached

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 83277

**\*83277\***

Page 4

April-16-12 2:27:34 PM

Item ID: D350-748-141TRN

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID: U/R

Stop

**\*NS2\***

Item Name: Crosstube Turning Detail

Start Date: 16/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 30/04/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC6- Inspect dimensions to drawing

0.00

**\*180\***

QC

Memo

0.00

Quality Control

NIA

190

Packaging

0.00

**\*190\***

Packaging

Memo

0.00

Packaging

Identify and stock in kanban rack  
Location: 46

DP 12-4-23

200

QC21- Final Inspection - Work Order Release

0.00

**\*200\***

QC

Memo

0.00

Quality Control

12-04-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

April-16-12 2:27:40 PM

Page 1

Work Order ID: 83277

\*83277\*

Parent Item: D350-748-141TRN

\*D350-748-141TRN\*

Parent Item Name: Crosstube Turning Detail

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 08-03-06 DD verified by:ec  
 IPP Rev B Removed polish 08.04.02 EC verified by : DD  
 IPP Rev C Remove LPS-3 08.06.23 EC verified by DD IPP Rev C  
 11.02.24 as per dwg rev.F DD verf: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6015-125		Manufactured	No			110	Each	44.0000	1	1			

\*D6015-125\*

Crosstube Material

\*\*

Location

Loc Qty

Loc Code

HALL

44

61380

4

72511

40

*DR 7MRL 12/04/18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 83277
<b>Description:</b> Crosstube Assembly (AS350/355 High Fwd)		<b>Part Number:</b> D350-748-141
<b>Inspection Dwg:</b> D350-748-141 <b>Rev:</b> F		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	<del>2.246</del>	+0.005/-0.000					
	2.180	+0.005/-0.000	2.185	/			
	2.180	+0.005/-0.000	2.185	/			
	2.237	+0.005/-0.000	2.242	/			
	2.272	+0.005/-0.000	2.275	/			
	2.306	+0.005/-0.000	2.310	/			
	2.339	+0.007/-0.000	2.340	/			
	2.339	+0.007/-0.000	2.345	/			
	0.062	+/-0.010	0.062	/			
	<del>0.26</del>	+/-0.030					Scrap
	<del>R0.063</del>	+/-0.010					
	<del>R0.50</del>	+/-0.030					
SIDE B	<del>2.246</del>	+0.005/-0.000					
	2.180	+0.005/-0.000	2.184	/			
	2.180	+0.005/-0.000	2.185	/			
	2.237	+0.005/-0.000	2.242	/			
	2.272	+0.005/-0.000	<del>2.275</del> 2.258		/		
	2.306	+0.005/-0.000	2.307	/			
	2.339	+0.007/-0.000	2.342	/			
	2.339	+0.007/-0.000	2.345	/			
	0.062	+/-0.010	0.052	/			
	<del>0.26</del>	+/-0.030					
	<del>R0.063</del>	+/-0.010					
	<del>R0.50</del>	+/-0.030					
122.27	<del>120.27</del>	+/-0.060	122.27			tape	QMM1-02

<b>Measured by:</b> mm.1/AFB	<b>Audited by:</b> [Signature]	<b>Preliminary Approval:</b>
<b>Date:</b> 12/04/18	<b>Date:</b> 12-4-23	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	06.11.09	New Issue (P/O D350-748-101)	KJ/JLM	
B	07.10.24	Dwg Rev updated	KJ/EC/DD	
C	11.01.20	Dwg Rev updated	KJ	
D	11.07.26	Tolerance revised for 2.339 dimensions	KJ	[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Item	Qty -141	Part Number	Description
1	X	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
2	1	D6015-125	CROSSTUBE (OR D6017-115)
3	2	D3502-1	SUPPORT
4	2	D2856-400-710	ABRASION STRIP
5	1	AELS-1032-225	INSERT
6	1	NAS1149D0363J	WASHER (OR AN960JD10)
7	2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
8	1	MS27039-1-10	SCREW

W/O 83277

#### GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6015-125 OR D6017-115  
FINISHED LENGTH = 122.270±0.06
- 2) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2  
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: DART PART NUMBER "D350-748-141" AND BATCH NUMBER ON INSIDE OF CUFF  
PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 30.45 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
- 9) BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.  
NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING. ACCEPTABLE TO VERIFY TENSILE STRENGTH BY HARDNESS TEST PER ASTM E18 TO 40-45 HRC.
- 12) INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 13) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 14) TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TIGHTENING.
- 15) MAX TWIST AFTER BENDING: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.25 (ZN C1-3).

PRELIMINARY ISSUE

Rw P91 9/12.03.06

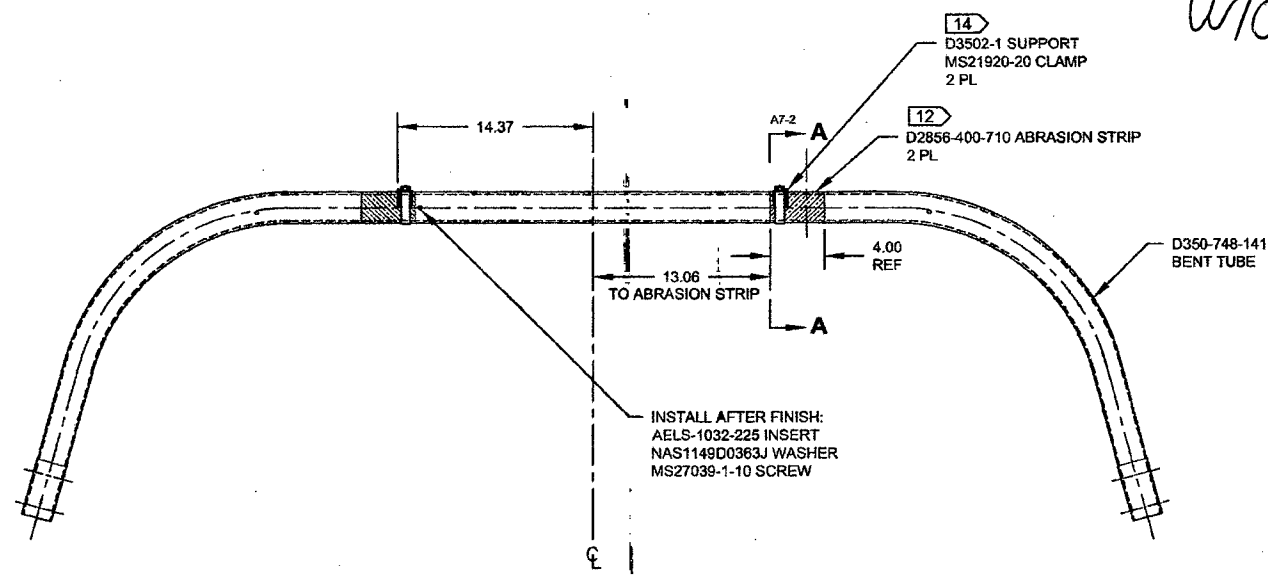
PG1	LENGTH 122.27 WAS 110.27 (C8-1), ADD BEND DIMS FOR LONGER TUBE (C6-3), REMOVE CUFF (D7-4)	CP	12.01.26
F	ADD HRC TEST OPTION (B8-1) PER PAR 09-040, ADD TWIST LIMIT (A8-1, C1-3), ADD D6015-125 OPTION (C8-1), STOCK DIM NOW MACHINED (D1-4)	CP	10.11.23
E	REVISE GENERAL NOTES; UPDATE TO CURRENT ADD STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A8-3); TOLERANCES (ZN C6-3, D1-3)	RF	09.08.30
D	MAG. PARTICLE AND CAD PLATE AS MFD.	CP	06.10.31
C	ADD CAD PLATING	CP	06.08.14
B	ADD D6017-115 & PRIME AND PAINT	CP	06.06.30
A	NEW ISSUE	CP	06.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.01.26		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

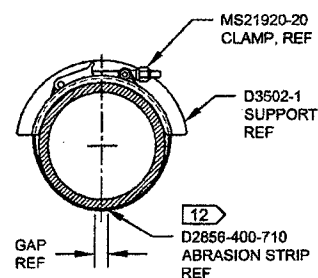
DRAWING NO. REV. G  
D350-748-141 SHEET 1 OF 4  
TITLE SCALE  
CROSSTUBE (AS 350/355 HI FWD) NTS

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w/0 83277



**D350-748-141  
ASSEMBLY DETAIL**



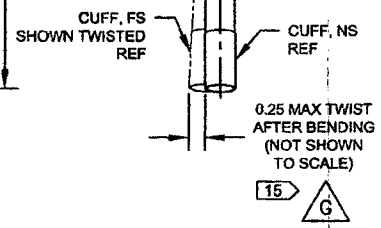
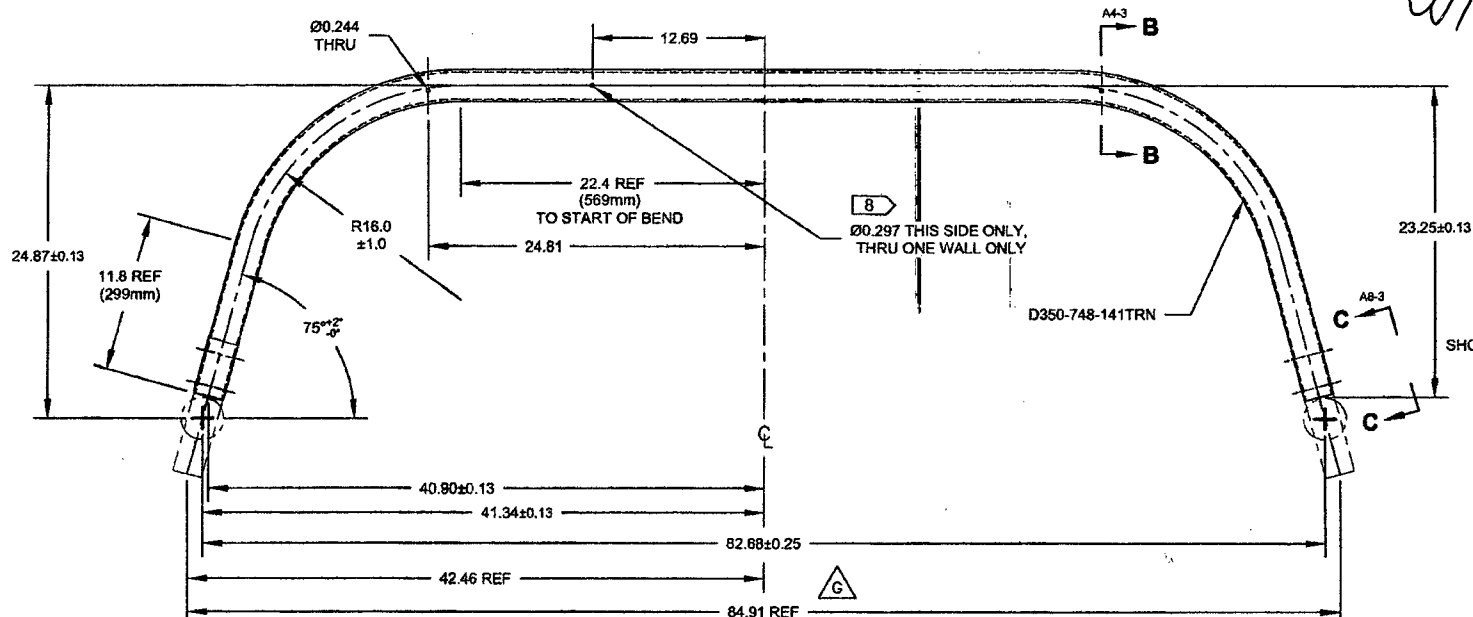
**SECTION A-A**  
SCALE 4X

**PRELIMINARY ISSUE**

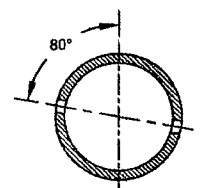
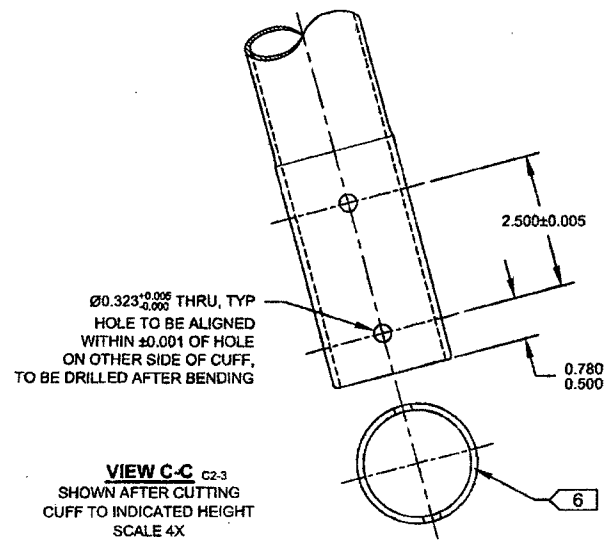
Rev. PG1 9/23.06

DESIGN	92	<b>DART AEROSPACE LTD</b>	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D350-748-141	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE (AS 350/355 HI FWD)	NTS
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W/O 83277



**D350-748-141**  
**BENDING AND DRILLING DETAIL** 10

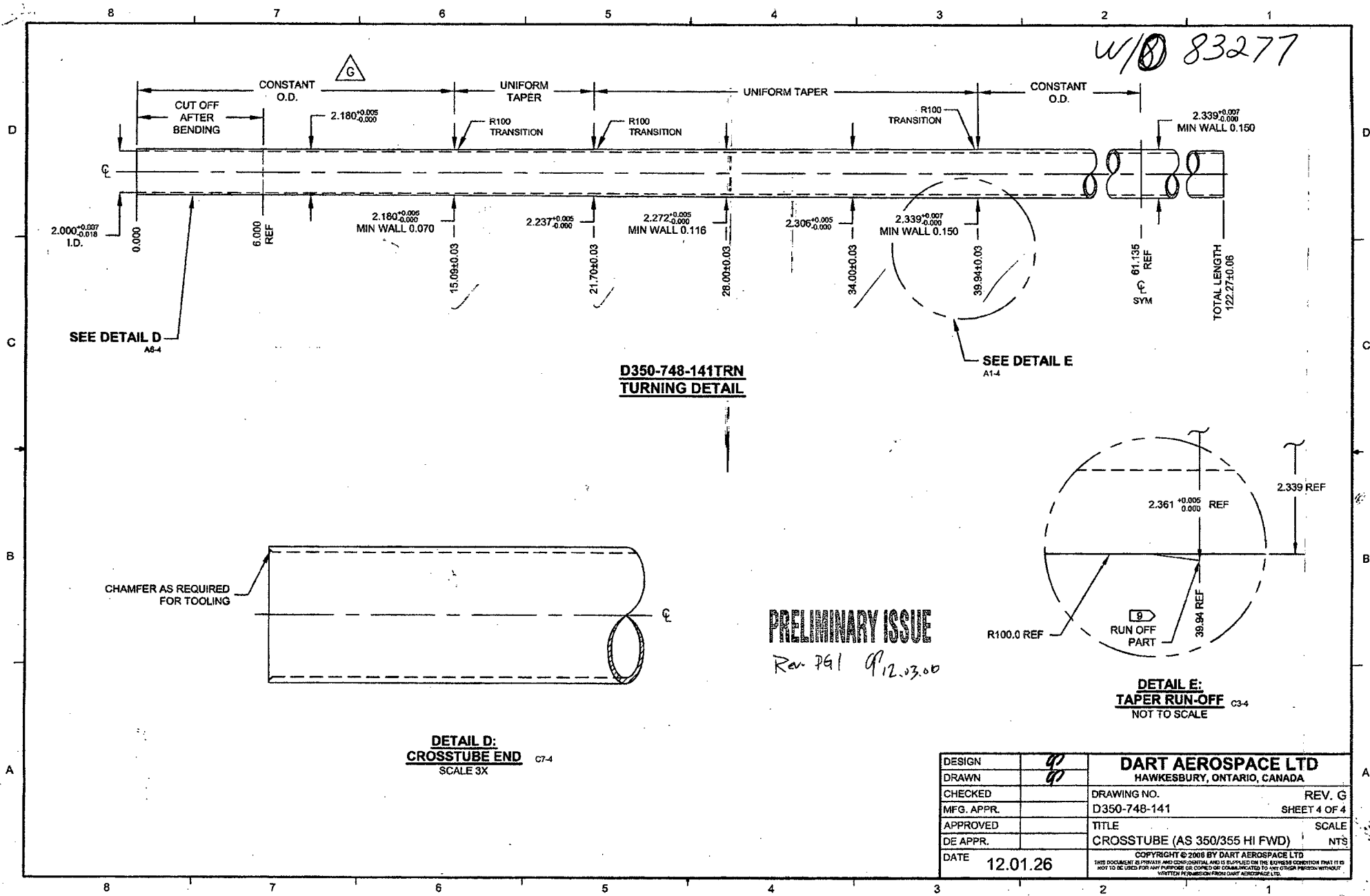


**SECTION B-B** D3-3  
SCALE 4X

**PRELIMINARY ISSUE**  
Rev. PG1 12.03.06

DESIGN	97	<b>DART AEROSPACE LTD</b>	
DRAWN	97	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D350-748-141	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE (AS 350/355 HI FWD)	NTS
DATE	12.01.26	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/8 83277

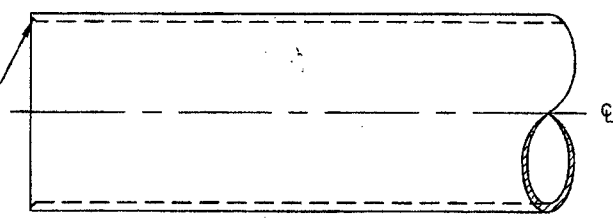


SEE DETAIL D  
A6-4

**D350-748-141TRN  
TURNING DETAIL**

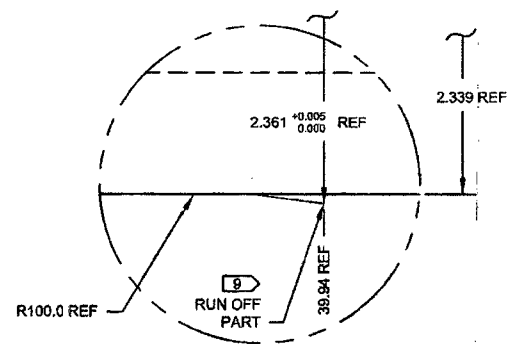
SEE DETAIL E  
A1-4

CHAMFER AS REQUIRED  
FOR TOOLING



**DETAIL D:  
CROSSTUBE END** C7-4  
SCALE 3X

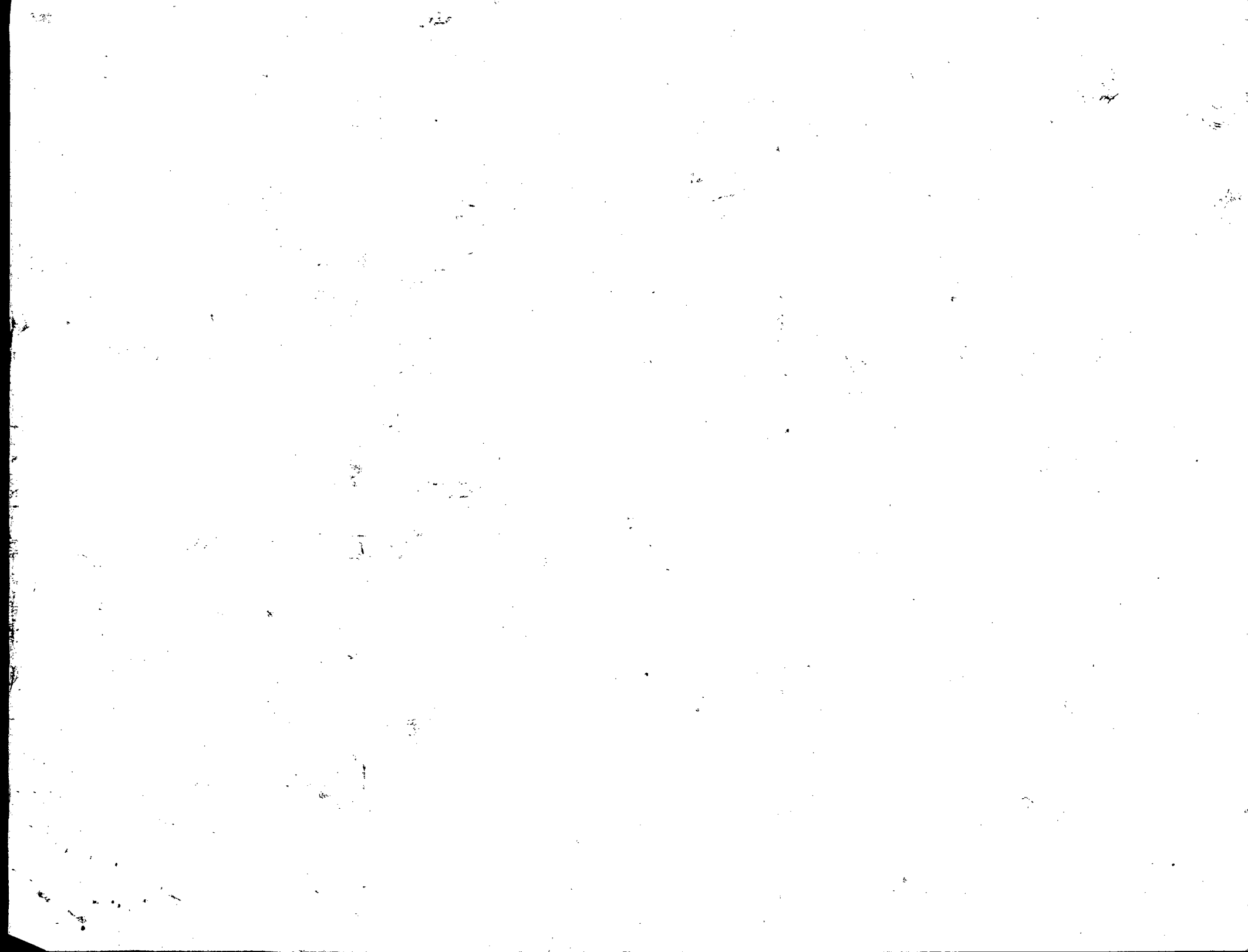
**PRELIMINARY ISSUE**  
Rev. 761 9/12.03.00



**DETAIL E:  
TAPER RUN-OFF** C3-4  
NOT TO SCALE

DESIGN	92	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	92		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D350-748-141	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE (AS 350/355 HI FWD)	NTS
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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 83277
<b>Description:</b> Crosstube Assembly (AS350/355 High Fwd)		<b>Part Number:</b> D350-748-141
<b>Inspection Dwg:</b> D350-748-141 Rev: <i>P61</i> <i>per prelim. Rev. P61</i>		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	<del>2.240</del>	+0.005/-0.000	—				
	2.180	+0.005/-0.000	2.183	/		Vern	CWL-08
	2.180	+0.005/-0.000	2.182	/		↑	
	2.237	+0.005/-0.000	2.241	/			
	2.272	+0.005/-0.000	2.276	/			
	2.306	+0.005/-0.000	2.309	/			
	2.339	+0.007/-0.000	2.342	/			
	2.339	+0.007/-0.000	2.345	/		↓	
	0.062	+/-0.010	.062	✓		✓	
	<del>4.26</del>	+/-0.030	—				
	<del>R0.063</del>	+/-0.010	—				
	<del>R0.50</del>	+/-0.030	—				
SIDE B	<del>2.240</del>	+0.005/-0.000	—				
	2.180	+0.005/-0.000	2.184	—		Vern	CWL-08
	2.180	+0.005/-0.000	2.184	—			
	2.237	+0.005/-0.000	2.240	—			
	2.272	+0.005/-0.000	2.270	✓	✓		
	2.306	+0.005/-0.000	2.304	✓	✓		
	2.339	+0.007/-0.000	2.346	/			
	2.339	+0.007/-0.000	2.345	/			
	0.062	+/-0.010	.062	—		↓	
	<del>4.26</del>	+/-0.030	—				
	<del>R0.063</del>	+/-0.010	—				
	<del>R0.50</del>	+/-0.030	—				
	122.270	+/-0.060	122.270	✓		Tape	27ML-02
	<del>122.27</del>	<del>+/-0.060</del>	—				

<b>Measured by:</b> <i>MM.L</i>	<b>Audited by:</b>	<b>Preliminary Approval:</b>
<b>Date:</b> 12/04/21	<b>Date:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	06.11.09	New Issue (P/O D350-748-101)	KJ/JLM	
B	07.10.24	Dwg Rev updated	KJ/EC/DD	
C	11.01.20	Dwg Rev updated	KJ	
D	11.07.26	Tolerance revised for 2.339 dimensions	KJ	<i>[Signature]</i>

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## ULTRA SONIC MEASUREMENTS

Side	LOCATION on tube	R1	R2	R3	R4
A	② 204	.134	.122	.104	.133
	② 404	.187	.169	.156	.174

B	② 204	.118	.172	.129	.186
	② 404	.176	.162	.170	.178

Part number	D350-748-141 TRJ.
Batch number	83277
Measured By	817/14/23